

Work Order ID 61931

Thursday, September 09, 2010 2:19:38 PM



Page 1

Item ID: D2330-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Frame

Start Date: 9/9/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/16/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-9-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D2330
2- remove identification marks and deburr

SY 10/09/09 (6x)

110

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

8:00/09

(x6)

120

0.00



Packaging

Identify as per dwg & Stock Location:

Basket call
Memo

0.00

Packaging

SY 10/09/09 6x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept

Revision ID:

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Start Date: 9/9/2010 Start Qty: 6.00

Required Date: 9/16/2010 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/13

CL 10/9/10

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, September 09, 2010 2:19:41 PM

Page 1

Work Order ID: 61931

Parent Item: D2330-1

Parent Item Name: Frame



Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	1,130.433	7.37	46.54737			
304 SQ Tube .75x.75x.065W													

10/09/09

Location

Loc Qty

Loc Code

MAT

1102.7893

112398

0

114482

0.0002

115494

522.7891

115593

580

WA

27.644385

114520

3.697385

115274

23.947

*46.55 + 7 (END BAR)
Scrap*

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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

G

G

G

G

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61931

10-9-09

RELEASED
G/R MP

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/-3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/-9/-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2330 SHEET 1 OF 6 TITLE BASKET ASSEMBLY (206B) SCALE NTS COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OTHER THAN THAT FOR WHICH IT WAS ORIGINALLY INTENDED.	
DRAWN	JB		
CHECKED	JB		
MFG. APPR.	JB		
APPROVED	JB		
DE APPR.	JB		
DATE	09.02.05		

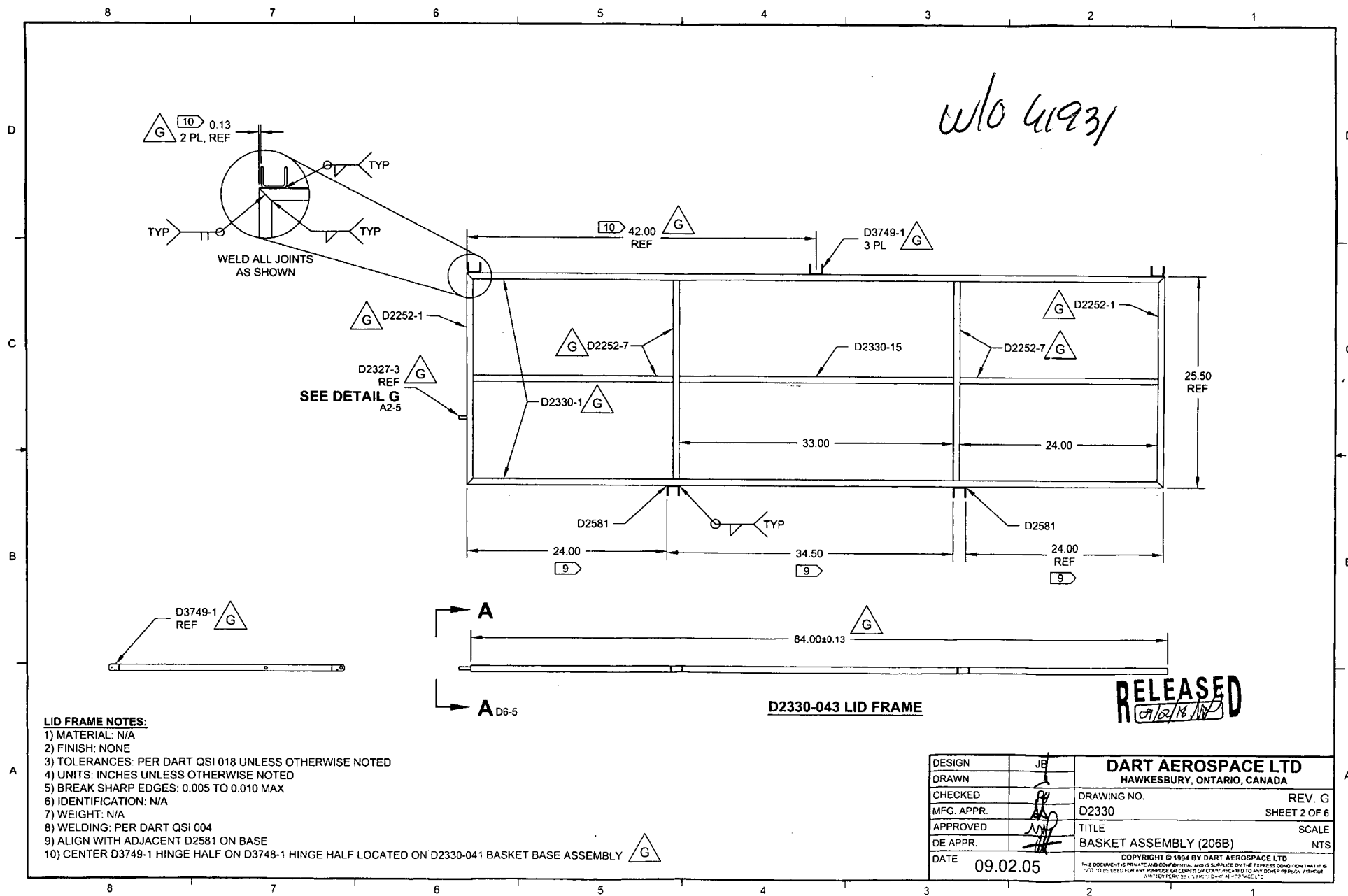
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



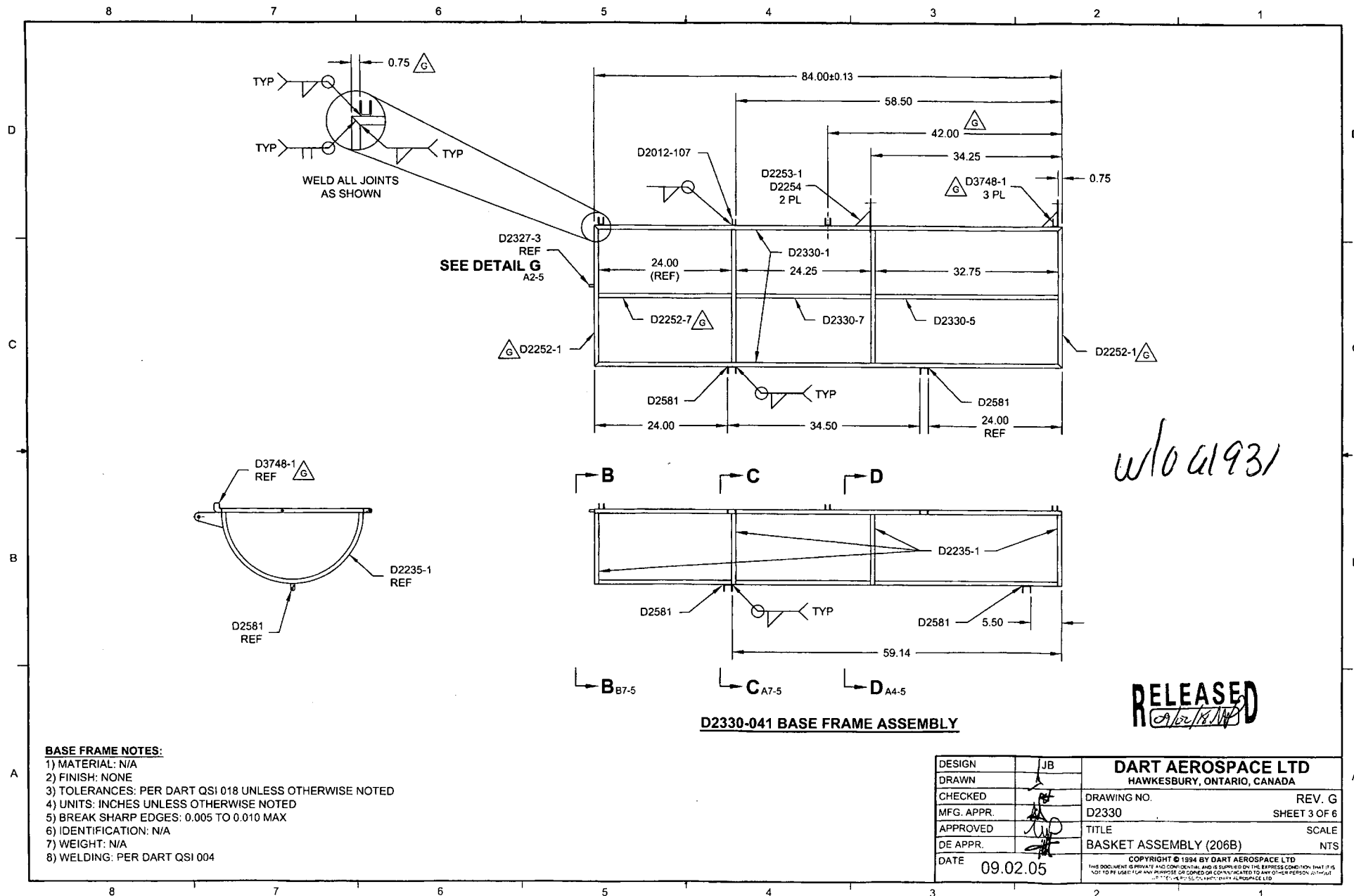
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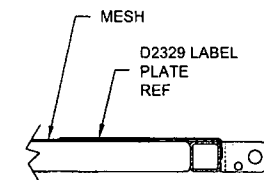
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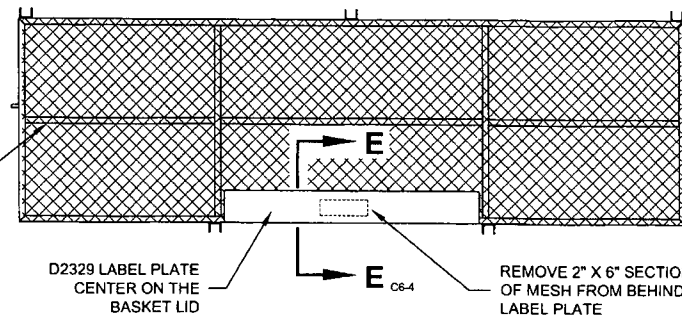
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

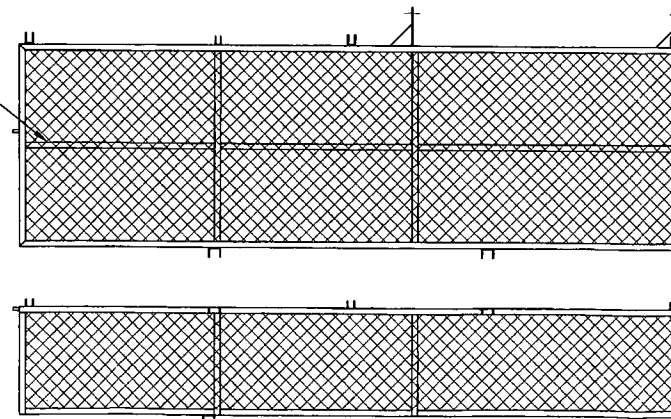


SECTION E-E C3-4
VIEW ROTATED 90° CCW

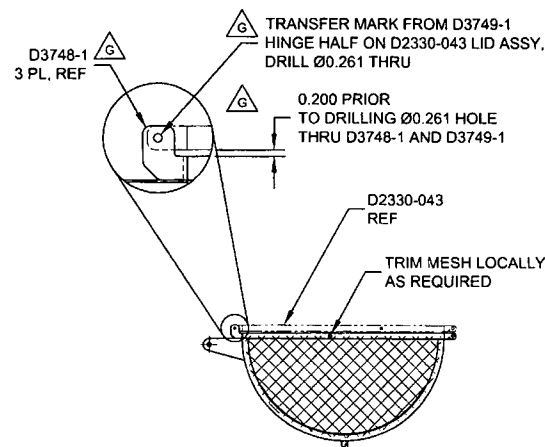
TACK WELD EACH
STRAND END OF
MESH TO FRAME



D2330-043 LID ASSEMBLY



D2330-041 BASE ASSEMBLY



ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2330	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
DATE	09.02.05	COPYRIGHT © 1994 BY DART AEROSPACE LTD	

WLO 61931

RELEASED
9/10/18

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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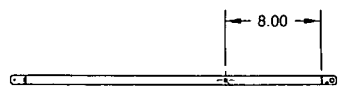
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D

C

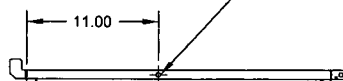
B

A



VIEW A-A A6-2

DRILL 3/8 HOLE AND
INSTALL D2327-3
SEE DETAIL G A2-5



VIEW B-B A5-3

D2581
REF

D2012-107
REF

D2581
REF

D2253-1
REF

EXPANDED
METAL

WELD D2581
WITH LARGE HOLE
ON THIS SIDE

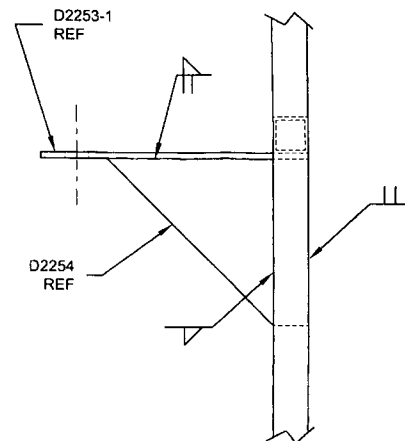
SECTION C-C A4-3

C2-5 F F

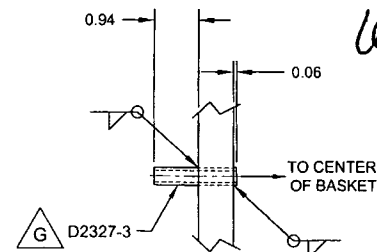
D2253-1
REF

EXPANDED
METAL

SECTION D-D A3-3



VIEW F-F B6-5
SCALE 4X



DETAIL G
SPACER INSTALLATION
SCALE 4X

u/o 4931

RELEASED
12/12/18

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8 7 6 5 4 3 2 1

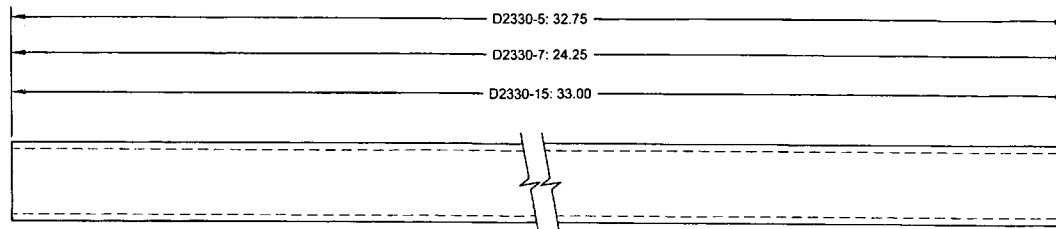
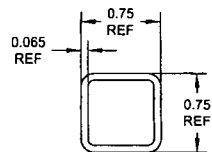
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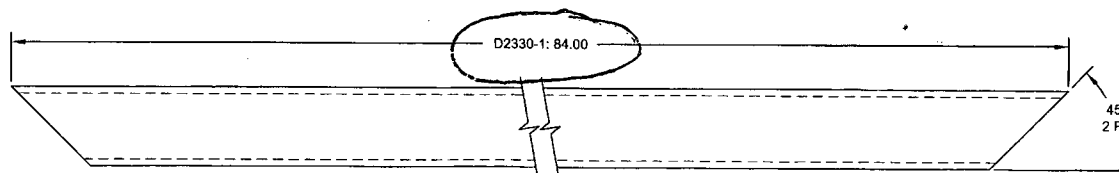
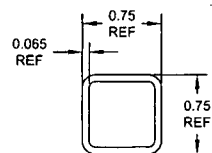
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D2330-5 FRAME
D2330-7 FRAME
D2330-15 FRAME



D2330-1 FRAME

u/o 01931

RELEASED
09/02/05

- NOTES:**
 1) FRAME MATERIAL: SEE SHEET 1
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

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